

Split

Work Order ID 76468-1

\*76468\*

Page 1

November-15-11 8:11:14 AM

Item ID: D2121 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clamp  
 Start Date: 15/11/2011 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 29/11/2011 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/15 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2121	Rev D								
100		0.00							
*100*	Large Fab								EL 12-3-25 (X10)
Large Fab	Memo	0.00							
Large Fab	Weld washer & wing nut as per Dwg D2121 & QSI 004 Identify as Wing Nut assembly								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*110*									QC 12.03.26
QC	Memo	0.00							10x
Quality Control									
120		0.00							
*120*	Small Fab								(3) FF 12-04-02
Small Fab	Memo	0.00							
Small Fab	Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121. Drill and deburr hole in coupling nut as per Dwg D2121. (Note: Install MS21042L4 Nut loosely) Cut D2771-BCFC-025-150 at 1.500"								



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 76468**

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**\*76468\***

Page 2

Item ID: D2121

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clamp

Start Date: 15/11/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(X3)			
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>004</u>  Memo	0.00 0.00				JB	(3)		12/04/03
150 <b>*150*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							12/4/3 JF

R12-04-3



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# Picklist Print

November-15-11 8:11:19 AM

Page 1

Work Order ID: 76468

\*76468\*

Parent Item: D2121

\*D2121\*

Parent Item Name: Clamp

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: D04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16-18 SS WING NUT  
\*5/16-18 SS WING NUT\*  
Wing Nut

Purchased No

100 Each 123.0000 1 10

\*\*

EL 12-3-28

Location

Loc Qty

Loc Code

Mezz

123

110084

100

16016

23

10

5/16WC  
\*5/16WC\*  
SS Flat Washer 5/16 FW516S1

Purchased No

100 Each 2,548.000 1 10

\*\*

EL 12-3-28

Location

Loc Qty

Loc Code

ST377

2548

115072

79

115174

47

116643

261

117332

1161

119343

1000

3

5/16-18 SS  
THREADED  
\*5/16-18 SS THREADED\*  
Threaded Rod 6.5" long

Purchased No

120 f 0.0000 0.541 10

\*\*

3

③ FF 12-04-02

5/16-18SS1COUPLING  
\*5/16-18SS1COUPLING\*  
Coupling Nut

Purchased No

120 Each 20.0000 1 10

\*\*

3

③ FF 12-04-02

Location

Loc Qty

Loc Code

Mezz

20

16016

20

3

③ FF 12-04-02

5/16 Jam nut  
12.03.30

M 110084

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item: D2121

**\*D2121\***

Parent Item Name: Clamp

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

5/16WC

Purchased

No

120

Each

2,548.000

1

10

\*\*

✓ **\*5/16WC\***

SS Flat Washer 5/16 FW516S1

③ FF 12-04-02

## Location

## Loc Qty

## Loc Code

ST377

2548

115072

79

115174

47

116643

261

117332

1161

119343

1000

FF 3

AN4-4A

Purchased

No

120

Each

44.0000

1

10

\*\*

✓ **\*AN4-4A\***

Bolt

③ FF 12-04-02

## Location

## Loc Qty

## Loc Code

FP-B

18

114615

18

ST355

26

114615

26

FF 3

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

1

10

\*\*

✓ **\*AN960.ID416\***

Washer

D2012-107

Manufactured

No

120

Each

49.0000

1

10

\*\*

✓ **\*D2012-107\***

Clevis

③ FF 12-04-02

## Location

## Loc Qty

## Loc Code

ST004

49

71602

11

75057

38

③ FF 12-04-02

FF 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D2121\***

Parent Item Name: Clamp

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

D2529 Manufactured No

120 Each

793.0000

*50*  
*12.03.30*  
*\*\* 5*

**\*D2529\***

Washer

Location

Loc Qty

Loc Code

ST016

793

71161

250

73486

43

76086

500

*FF*  
*3* 12-04-02

D2771-BCFC-025-150 Manufactured No

120 Each

722.0000

1

10

**\*D2771-BCFC-025-150\***

Bolt

**\*\***

Location

Loc Qty

Loc Code

Mezz

722

8754

722

*FF*  
*3* ③ FF 12-04-02

D2771-LCC-025 Manufactured No

120 Each

707.0000

1

10

**\*D2771-LCC-025\***

Lock Nut

**\*\***

Location

Loc Qty

Loc Code

Mezz

707

4554

6

8493

701

*FF*  
*3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 76468

**\*76468\***

Parent Item: D2121

**\*D2121\***

Parent Item Name: Clamp

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

120

Each

11,632.00

1

10

**\*MS21042I 4\***

**\*\***

Nut

③ FF 12-04-02

## Location

## Loc Qty

## Loc Code

ST300

632

117441

51

117601

374

118451

133

118927

74

ST516

6000

119017

6000

ST518

5000

119075

5000

20 3  
FF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

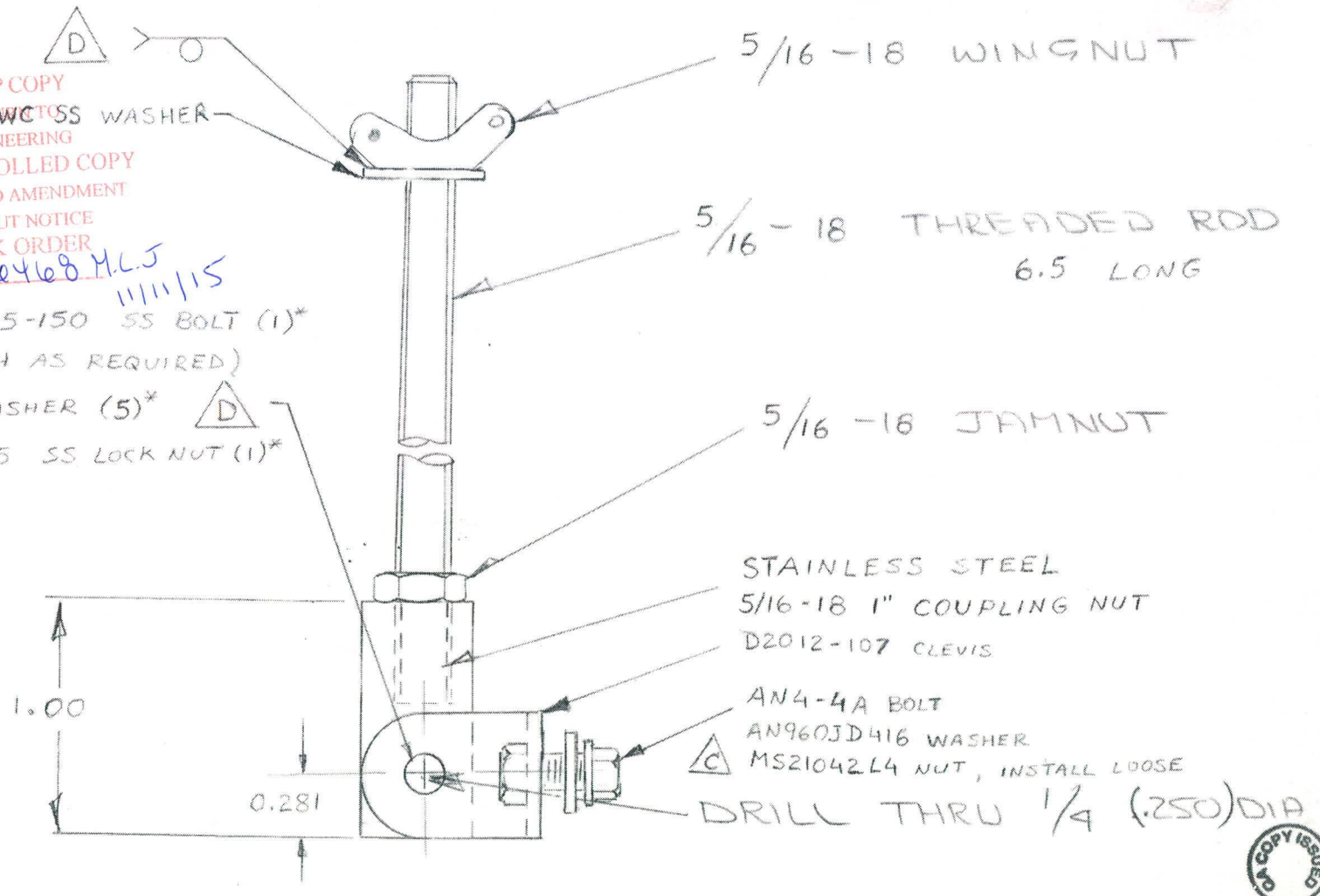
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△ C SHOP COPY  
 5/16-18 W.C. SS WASHER  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 76468 M.L.S  
 11/11/15

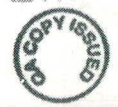
D2771-BCFC-025-150 SS BOLT (1)\*  
 (CUT TO LENGTH AS REQUIRED)  
 D2529 SS WASHER (5)\* △ D  
 D2771-LCC-025 SS LOCK NUT (1)\*  
 \*OR EQUIVALENT



STAINLESS STEEL  
 5/16-18 1" COUPLING NUT  
 D2012-107 CLEVIS  
 AN4-4A BOLT  
 AN960JD416 WASHER  
 MS21042L4 NUT, INSTALL LOOSE

DRILL THRU 1/4 (.250) DIA

RELEASED  
 04-05-04



D	C	B	-	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
1	2	3	4	DRAWN		BASIC CODE	DIA. DASH NO. N=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.		<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA			
5	6	7	8	APPROVED		D=HOLE DRIFT-HO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN		DATE	TITLE CLAMP, BATTERY		
9	10	11	12	DESCRIPTION OF CHANGE		BASIC CODES		DESIGN		1992	CODE	DWG NO.	REV
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. S. 2742 5. HOLES PER AND 10387					LIMITS 1. TOLERANCES — .XX ± .030 .XXX ± .010 2. ANGLES 2 1/2° 3. PARALLELISM ± .0075 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		BASIC CODES BJ=MS20470AD BB=MS20426AD		CHECKED CLIENT		SCALE SHIT 1 OF 1		



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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